

# Work Order ID 65075

Thursday, January 06, 2011 10:39:12 AM



Page 1

Item ID: D3278-2

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 1/6/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3278	Rev C								

100

0.00



SHEAR

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut blank: 2.00" x 1.00" x 2.550" long

*SL 11/02/01*

40

~~0~~

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

1- Machine as per Folio FA405 and Dwg D3278-2- Deburr and Tumble Identify as D3278-2

*SL 11/02/07*

(40)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

*SL 11/02/07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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**NOTE:** Date & initial all entries

**Work Order ID 65075**

Thursday, January 06, 2011 10:39:12 AM

Page 3

Item ID: D3278-2

Accept

Revision ID:

Item Name: Support

Start Date: 1/6/2011 Start Qty: 40.00

Required Date: 1/13/2011 Req'd Qty: 40.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

160/24 (40)

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

170/24 (40)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

180/24

MF

11-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, January 06, 2011 10:39:16 AM

Page 1

Work Order ID: 65075

Parent Item: D3278-2

Parent Item Name: Support



Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐  
IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	49.1103	0.2337	9.84			



6061-T6 Bar 1.00 x 2.00



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	47.652	
112567	0	
114415	3.75	
115045	3.902	
115952	40	
MAT03	1.4583	
112567	1.4583	

1116623

x 9.84"

sub 11/02/01

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	65075
<b>Description:</b> Support		<b>Part Number:</b>	D3278-2
<b>Inspection Dwg:</b> D3278 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST



☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.098	✓		Vern SL-3	
0.359	+/-0.005	.359	✓			
0.609	+/-0.010	.613	✓			
0.250	+/-0.010	.250	✓			
1.480	+/-0.005	1.480	✓			
R0.125	+/-0.010	.125	✓			
0.119	+0.005/-0.004	.121	✓			
2.439	+/-0.010	2.439	✓			
1.980	+/-0.010	1.980	✓			
R0.13	+/-0.030	.13	✓			
Ø0.257	+0.005/-0.000	.257	✓			
R0.375	+/-0.010	.375	✓		R-G	
0.875	+/-0.010	.875	✓			
0.500	+/-0.010	.499	✓			
R0.400	+/-0.010	.400	✓			
R1.00	+/-0.030	1.00	✓			
1.720	+/-0.010	1.720	✓			
R0.125	+/-0.010	.125	✓		R-G	
0.125	+/-0.010	.128	✓			

<b>Measured by:</b>	SL
<b>Date:</b>	11/02/16

<b>Audited by:</b>	ML
<b>Date:</b>	11/02/16

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue      P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	<div style="display: flex; align-items: center;"> <div style="margin-right: 20px;">  </div> <div>  </div> </div>

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>92</i>	DRAWN BY <i>SC</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV.- C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
*07-08-06*

## D3278-041 SUPPORT ASSEMBLY

D3278-3 SPACER

MS20426AD3-6 RIVET  
(4 PLACES)

D3278-1 SUPPORT

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *65075*

D3278-2 SUPPORT

AN4-13A BOLT (1)  
AN960JD416 WASHER (2)  
MS21042L4 NUT (1)  
(2 PLACES)

D2230-1 CLAMP  
(2 PLACES)

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

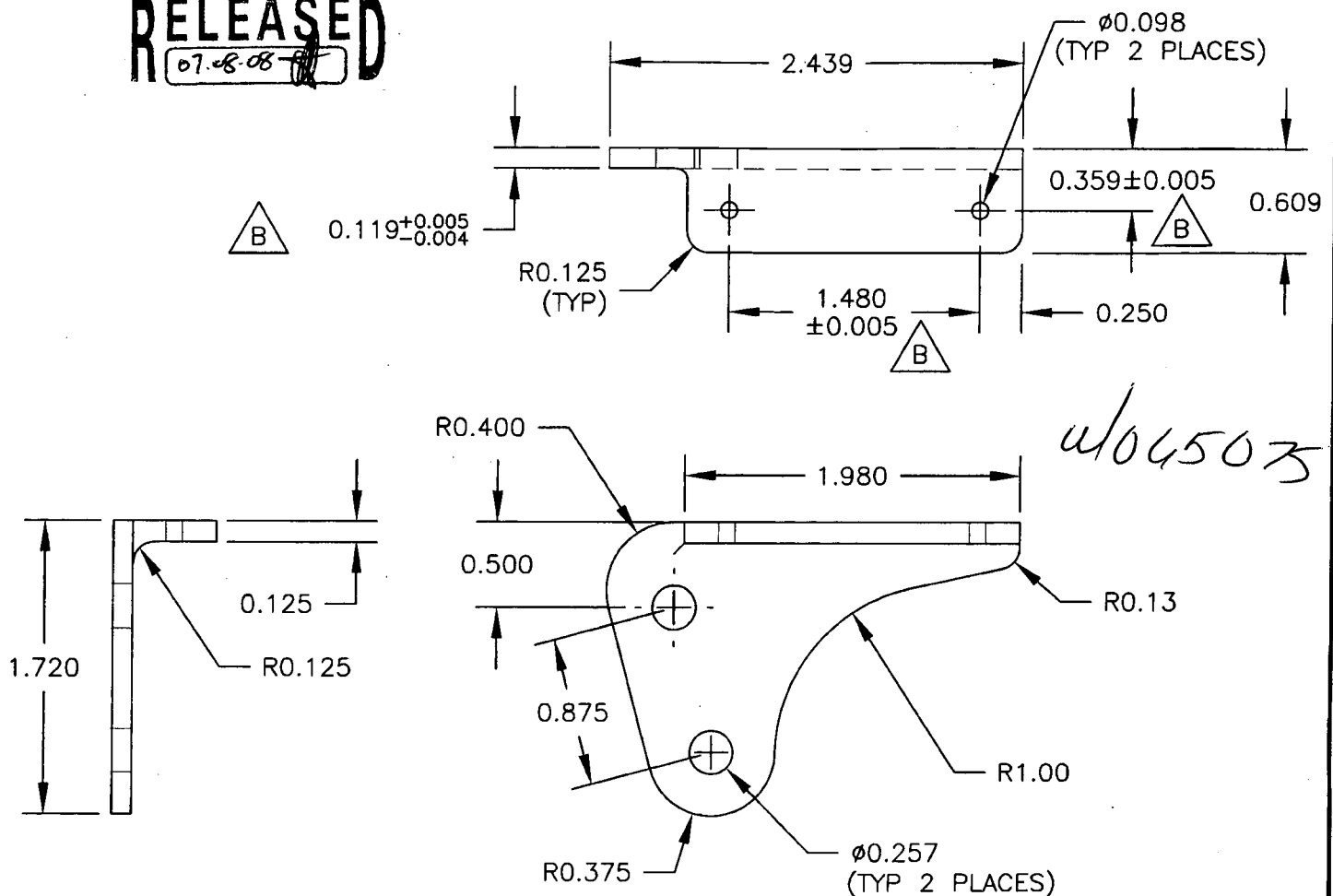
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**NOTE:** Date & initial all entries

**DART**

DESIGN <i>gp</i>	DRAWN BY <i>bc</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>js</i>	APPROVED <i>jt</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
*07-8-08***D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRJT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

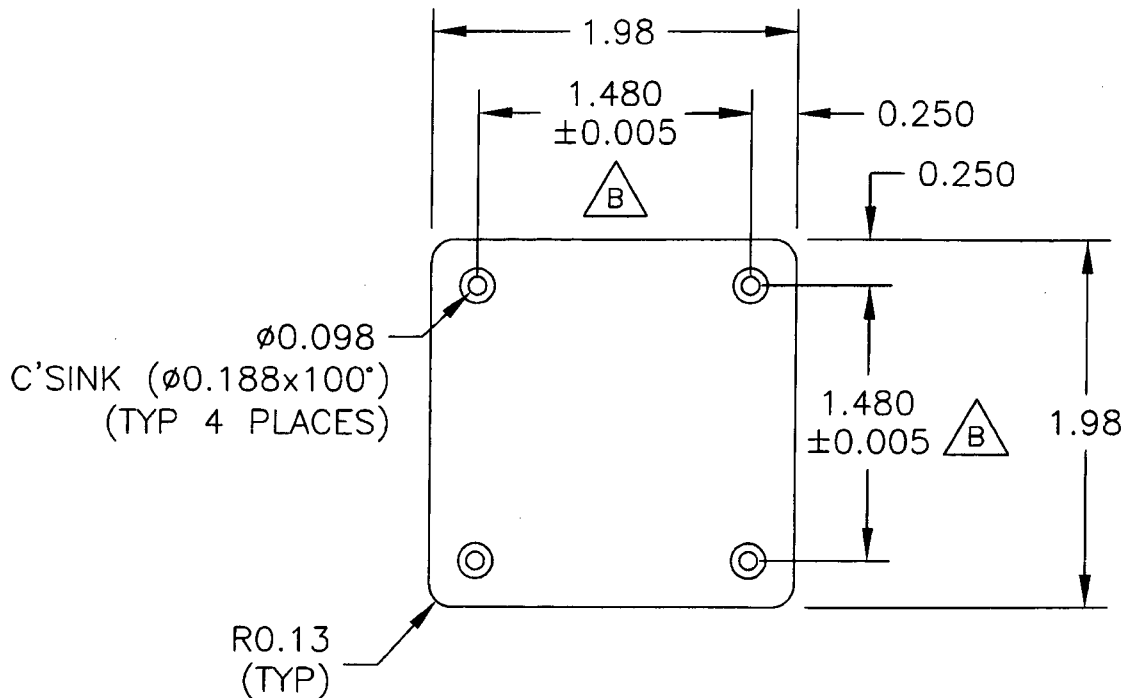
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**NOTE:** Date & initial all entries

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08*u/o 65075***D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date, & initial all entries